

SJIT
Work Order ID 71572

Wednesday, July 06, 2011 1:20:14 PM



Page 1

Item ID: D3414-041

Accept

Revision ID:

Item Name: Lug Assembly

Start Date: 7/6/2011



Start Qty: 16.00



Setup Start



Required Date: 7/20/2011

Req'd Qty: 16.00



Cust Item ID:



Customer:

Reference:

Approvals: Process Plan: *CL*

Date: 11/07/08 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3414-1 Dwg Rev: <i>C</i> Prog Rev: <i>C</i>								<i>B 11-7-13</i>
<i>304 .100</i>	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	Memo	0.00							
QC									
Quality Control									

HB 11-7-13

(54)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71572

Wednesday, July 06, 2011 1:20:14 PM



Page 2

Item ID: D3414-041

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 7/6/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S u l o 7 / 3

 count
724

130



Brake NC

Brake NC

Memo

1-Deburr

2-Form using DT8254 as per Dwg D3414

0.00

SB u l o 7 / 4 /

140



Large Fab

Large Fab

Memo

1- Weld using location Jig DT9625 as per Dwg D3414
A/R S.S. welding rod Batch: M117659

0.00

E 11-8-2

 X16
PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.07.28	140	Stock 1x D3414-1 underline B/N	EZ	11-7-28	1	u 11.07.28	S 11.08.03

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71572

Wednesday, July 06, 2011 1:20:14 PM



Page 3

Item ID: D3414-041

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 7/6/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

QC

Quality Control

Operation
Description

QC9- Inspect visual per QSI004- Fusion Welds

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S u l o r l o z

(16)

170



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M118439

0.00

Memo

0.00

START TIME: 7:00 AM
OVEN TEMPERATURE: 400°F
FINISH TIME: 7:30 AM

16 of 41 11/10/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71572

Wednesday, July 06, 2011 1:20:14 PM



Page 4

Item ID: D3414-041

Accept



Setup

Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 7/6/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

180



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



Packaging

Packaging

Identify as per dwg & Stock Location:

179

0.00

0.00

16x Ø m h 11/08/04

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/18/11 6x Ø Ø

OK 11/08/08

11-08-5 (14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, July 06, 2011 1:20:11 PM

Work Order ID: 71572



Parent Item: D3414-041



Parent Item Name: Lug Assembly

Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP A□05.09.13□New issue KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA 304/316 0.100" Sheet		Purchased	No			100	sf	147.3000	0.155	2.48			<i>(B) 1-7-13</i>

Location	Loc Qty	Loc Code
MAT019	147.3	
113062	118.3	
113077	29	

D3414-3 Lug	Manufactured	No		140	Each	21.0000	1	16					<i>Q2 11-8-2</i>
----------------	--------------	----	--	-----	------	---------	---	----	--	--	--	--	------------------

Location	Loc Qty	Loc Code
WA	21	
69882	21	

70412 X16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

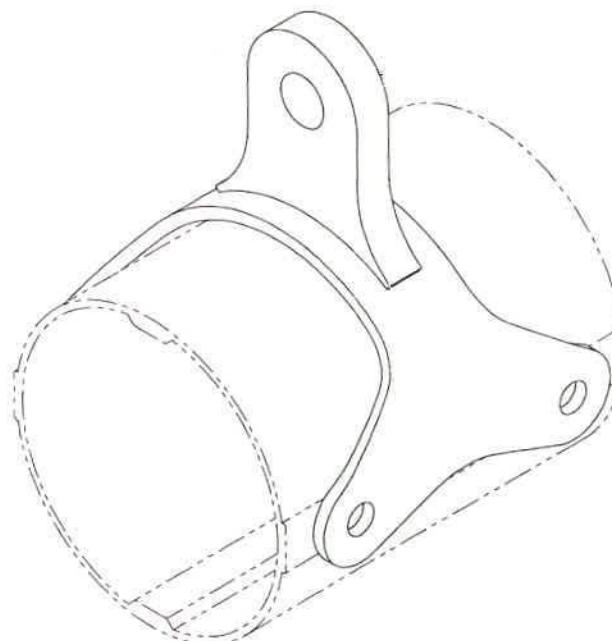
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

8 7 6 5 4 3 2 1

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WITHOUT NOTICE
WORK ORDER
NO. 71572

CL 11/07/06

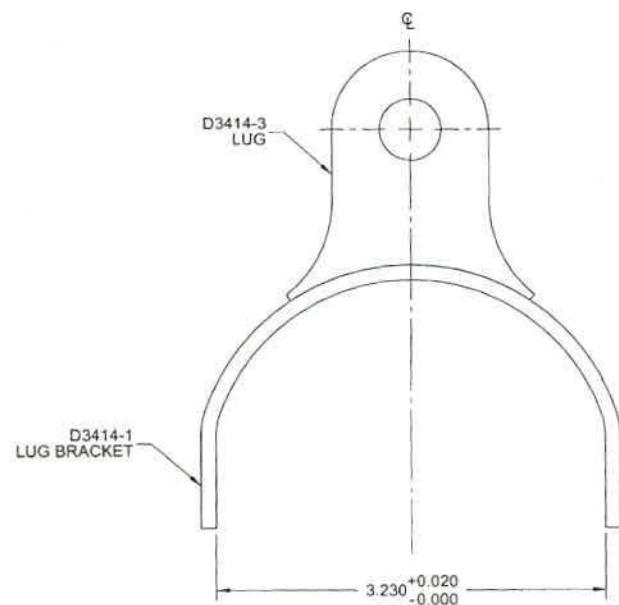
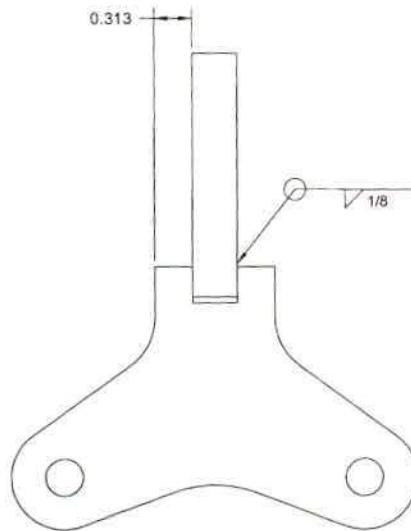
RELEASED
09/06/06/06

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS. TRIM SPOTS REMOVED. FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	CP	HAWKSLEY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3414	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG ASSEMBLY	NTS
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D3414-041 LUG ASSEMBLY

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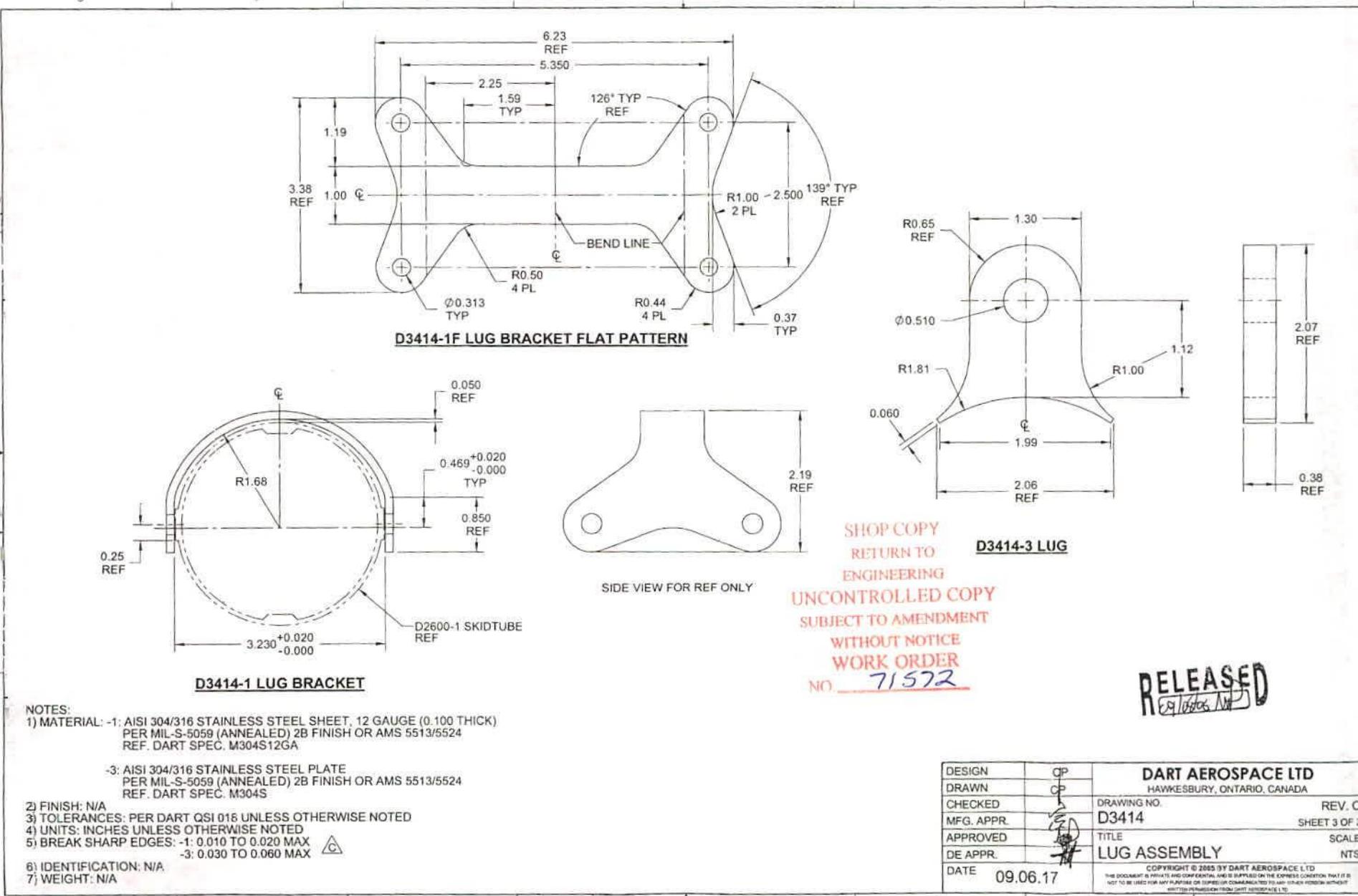
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MFG. APPR.	<i>ED</i>	REV. C
APPROVED	<i>M</i>	D3414
DE APPR.	<i>#</i>	SHEET 2 OF 3
DATE	09.06.17	TITLE
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8 7 6 5 4 3 2 1

A

A



DART AEROSPACE LTD	Work Order:	71572
Description: Lug Bracket	Part Number:	D3414-1
Inspection Dwg: D3414 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	11-7-13	Date:	11/07/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue P/O D3414-041	KJ/DD	
B	09.05.27	Dimensions updated per Dwg Rev B	KJ	
C	09.10.16	Dwg Rev updated to Rev C	KJ	